

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in this application:

LISTING OF CLAIMS:

1. (Currently Amended) A method for manufacturing a three-dimensional pleated filter material from a thermally bonded non woven fabric, comprising:
forming a single fibrous web from undrawn and drawn synthetic fibers;
pre-heating the fibrous web; and
calendering the single fibrous web between sinusoidally profiled calender rolls in a single calendering step without subsequent re-heating, the sinusoidally profiled calender rolls heated to a temperature up to the melting point of the undrawn fibers, wherein during the single calendering step, the undrawn fibers in the single fibrous web form bonds in a tension free manner between the ~~non-heated~~ profiled calender rolls to form the ~~non woven fabric~~ three-dimensional pleated filter material, wherein the bonds of the ~~non woven fabric~~ are of equal strength over its cross-section, wherein the ~~non woven fabric~~ three-dimensional pleated filter material is formed without the use of flat bonding, and wherein during the single calendering step, spacers are formed in the non woven fabric via bonding of the undrawn fibers to thereby form the filter material providing the filter material with a stable three-dimensional pleated shape.

Claims 2 to 8. (Canceled).

9. (New) A method for manufacturing a pleated filter material, comprising:
forming a single fibrous web from undrawn and drawn synthetic fibers; and
calendering the single fibrous web between profiled calender rolls,
wherein during the calendering step, the undrawn fibers in the single fibrous web form bonds between the profiled calender rolls and form spacers in the non woven fabric providing the filter material with a stable three-dimensional pleated shape.

10. (New) The method of claim 9, wherein the profiled calender rolls are heated to temperatures up to the melting point of the undrawn fibers.

11. (New) The method of claim 9, further comprising preheating the single fibrous web to temperatures up to the melting point of the undrawn fibers, the calender rolls not heated.

12. (New) The method of claim 9, wherein the spacers are formed by elevations with heights corresponding to at least one quarter the thickness of the pleated filter material.

13. (New) The method of claim 9, wherein the calender rolls have essentially a sinusoidal surface profiling.

14. (New) The method of claim 9, wherein a ratio of (i) a height of surface profiling on the calenders in a radial direction and (ii) axial width between adjacent vertices is between approximately 0.1 and 0.2.